

**Work Order ID 85657**

Wednesday, June 13, 2012 9:55:44 AM

**\*85657\***

Page 1

Today?

Item ID: D350-567-141

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Window Closeout Installation

Start Date: 6/13/2012 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 6/14/2012 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: *MF* Date: *12-06-13* Tooling:Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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DSI 9590

C

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPP D350-567-141 CHG002

*6/12/12**MCS 12/06/13*

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

*2x**SD 12-6-13*

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*8/12/12**(A)*

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**\*85657\***

Page 2

Item ID: D350-567-141

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Floor Window Closeout Installation

Stop **\*NS2\***

Start Date: 6/13/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 6/14/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00

**\*130\***

Packaging

0.00

Packaging

Memo

Identify and pack for shipping as per PPP D350-567-141

Location: **59A****Rev A**

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

(2x) **6/12/12**

**MLJ 12/07/12**

**MLJ 12/07/12**

# Picklist Print

Wednesday, June 13, 2012 9:55:43 AM

Page 1

Work Order ID: 85657

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 6/13/2012

Required Date: 6/14/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER  
ECN12-511 DD VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S D3802-1 Window Seal 7 MEASUR S 7 loc 13 7 (D3802-1-024) GUT (1) AT 24" AS PER DWG, PER KIT.		Manufactured	No			110	f	506.7500	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST412		506.75							
				56881		0.75							
				81021		6							
				81868		500							
S D4434-041 Fwd Bracket Assembly		Manufactured	No			110	Each	4.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		-4							
				80662		4							
				ST441		8							
S D4434-047 Cover Assembly		Manufactured	No			110	Each	11.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST441		11							
				82291		11							
S D4435-045 LAR Bellcrank Cover Assembly		Manufactured	No			110	Each	10.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST442		10							
				82290		10							
S D4435-9 Bracket		Manufactured	No			110	Each	22.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST441		22							
				82294		11							
				83474		11							

D-6-B

4X

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Work Order ID: 85657

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 6/13/2012

Required Date: 6/14/2012

Start Qty: 2.00

Required Qty: 2.00

D4436-041  
Aft Bracket Assembly

Manufactured No

110 Each 0.0000

1

B82286.5

## Location

## Loc Qty

## Loc Code

ST -9

ST441 9

D4441-1

Rubber Seal

Manufactured No

110 f 60.3626

2

4

80763

(D4441-1-240) SCUT (1) AT 24.00" PER KIT

## Location

## Loc Qty

## Loc Code

prelim 6.119

74760 6.119

ST413 54.2436

79385 47.0476

80763 7.196

AN3-3A

Bolt

Purchased No

110 Each 304.0000

7

SP 14

## Location

## Loc Qty

## Loc Code

ST350 304

120423 304

AN525-832R7

Screw

Purchased No

110 Each 528.0000

2

14X

SP 4

## Location

## Loc Qty

## Loc Code

ST345 528

120519 68

120560 460

MS21042L06

Nut

Purchased No

110 Each 216.0000

7

4X

SP 12-6-13

## Location

## Loc Qty

## Loc Code

ST300 216

118354 2

119109 1

119758 1

121444 112

121556 100

4X

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Shop Packet Print

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Work Order ID: 85657

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 6/13/2012

Required Date: 6/14/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Nut

Purchased No

110 Each 167.0000

2

## Location

## Loc Qty

## Loc Code

ST300

167

121524

167

Purchased No

110 Each 1,902.0000

5

## Location

## Loc Qty

## Loc Code

ST300

1902

115835

4

117885

32

119017

884

119075

138

121349

61

121444

783

Purchased No

110 Each 292.0000

2

## Location

## Loc Qty

## Loc Code

302

48

121185

48

ST301

28

118614

8

119546

20

ST302

216

106042

2

120308

13

120833

1

121444

100

121524

100

Purchased No

110 Each 170.0000

7

## Location

## Loc Qty

## Loc Code

ST293

170

121039

170

MS21059L3

Nut Plate

MS35206-229

Screw

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Page 4

Work Order ID: 85657

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 6/13/2012

Required Date: 6/14/2012

Start Qty: 2.00

Required Qty: 2.00

~~NA51149F0332P~~  
WASHER

Purchased No

110 Each 596.0000

12 24

Location

Loc Qty

Loc Code

ST275

596

117735

13

119225

10

120986

200

121259

200

121584

9

121825

161

17317

3

24x

~~NA51149FN616P~~  
WASHER

Purchased No

110 Each 851.0000

14 28

Location

Loc Qty

Loc Code

ST275

851

117317

15

120560

836

28x

~~NA51149FN816P~~  
WASHER

Purchased No

Each 755.0000

8P 12-6-13

Location

Loc Qty

Loc Code

ST275

755

117316

215

121039

540

4x

## 2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)

C

## 3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

## 4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
  - D350-567-115 — OK to remove D3295-041
  - D350-567-031 — OK to remove D3212-1
  - D350-567-011 — OK to remove D2214
  - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: D. Shepherd  
D. SHEPHERD (DE # 02)

DATE: 12.03.13  
CERT. NO.: SH92-18  
ISSUE NO.: 6

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>JS</u>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 12
APPROVED	<u>JS</u>	TITLE	SCALE
DE APPR.	<u>JS</u>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	12.03.13	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	